

Work Order ID 57101

March 22, 2010 9:07:30 AM

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**PROTOTYPE
PRELIMINARY ISSUE**



Item ID: D4058-042

Accept

Revision ID:

Item Name: Ski Section Assembly, Fwd RH

Start Date: 3/22/10 Start Qty: 1.00

Required Date: 3/23/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4058

-PAI Rev. A

100



HandThermo

Hand Finishing Thermoforming

Memo

Pick Kit

0.00

0.00

Wh 10/03/30 (P)

110



HandThermo

Hand Finishing Thermoforming

Memo

1- Assemble as per Dwg D4058-042

0.00

0.00

Wh 10/03/30 (P)

2- Use wearplate to locate and to transfer drill holes in ski as per dwg and use 0.375" unibit to open wearplate mounting holes to finish size.

3 use wearbar to locate + transfer drill as per dwg. install wearbars.

120



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

1 1004.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4058-042

Accept



Setup Start



Revision ID:

Stop



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Start Date: 3/22/10 Start Qty: 1.00



Required Date: 3/23/10 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

W/O 57404

MK 10-4-12

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12

MK 10-4-8

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Picklist Print

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Work Order ID: 57101

Parent Item: D4058-042

Parent Item Name: Ski Section Assembly, Fwd RH


Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-12A  Bolt		Purchased	No			100	Each	324.0000	6.0000			

Warehouse

Location

Main Warehouse

ST357

Loc Qty

Loc Code

111605

324

111925

13

112314

3

6071

300

8

AN4-6A

Purchased

No

100

Each

1,239.0000

14.0000

Bolt

Warehouse

Location

Main Warehouse

ST356

Loc Qty

Loc Code

112720

1239

112829

39

112933

300

113149

300

600

D4058-2

Manufactured

No

100

Each

0.0000

1.0000

Ski Section, Fwd RH

D4067-041

Manufactured

No

100

Each

0.0000

5.0000

Joggled Wearplate

Batch. 57099

56342

14 DL 10/03/30

x1 DL 10/03/30

x5 DL 10/03/30

W/O:		WORK ORDER CHANGES					
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D4069-1 		Manufactured	No			100	Each	0.0000	6.0000			
Spacer MS21043-4 		Purchased	No			100	Each	725.0000	20.0000			
Nut 												

Batch 56351

x6. DL 10/03/30.

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST301	685	
112314	100	
112492	11	
113064	174	
114181	400	

NAS1149F0432P

Purchased

No

100

Each

403.0000

20.0000

Washer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST275	403	
110098	200	
112940	100	
18057	103	

20 DL 10/03/30

20 DL 10/03/30

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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NAS1149F0463P  Washer		Purchased	No			100	Each	229.0000	20.0000			

Warehouse

Location

Main Warehouse

ST275

108246

114223

Loc Qty

229

29

200

Loc Code

20 Wk 10/03/30

AW3C5A BOLT
MS21043-3 NUT
D4015-041 Washer.

M114108 X (13)
M112314 Y (13)
M53956 X (6)
M53818 X (7)

Wk 10/03/31
Wk 10/03/31
Wk 10/03/31

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Shop Packet Print

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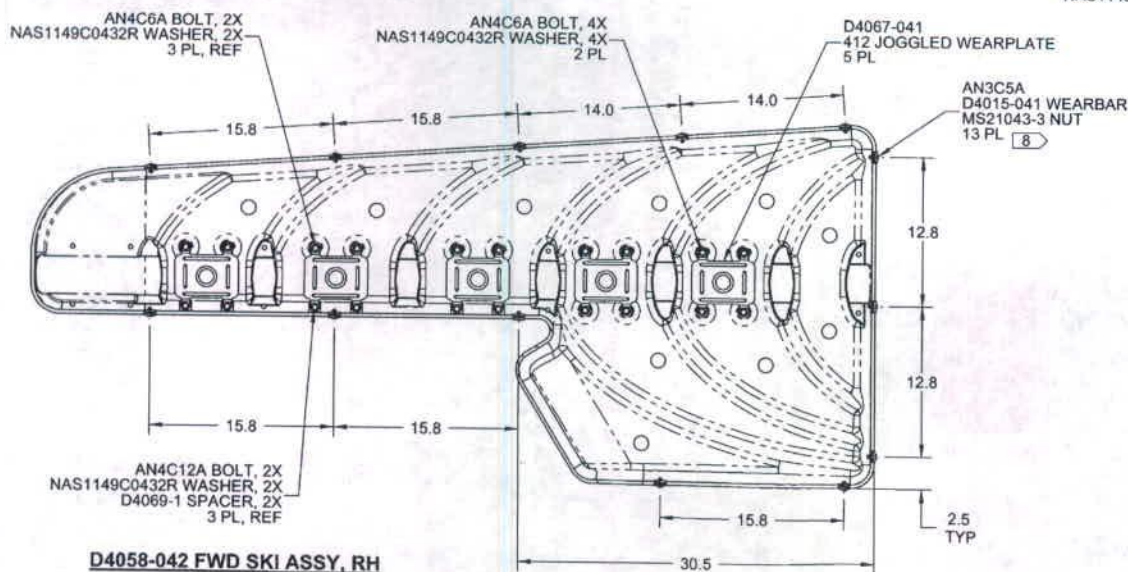
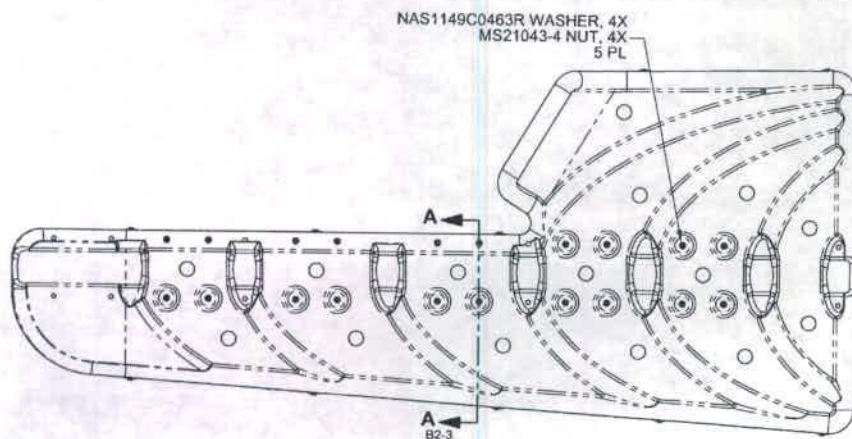
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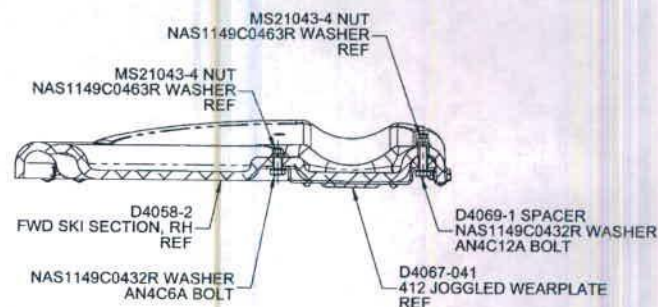
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ITEM	QTY	P/N	DESCRIPTION
1	X	D4058-042	FWD SKI ASSY, RH
2	13	D4015-041	WEARBAR
3	1	D4058-2	FWD SKI SECTION, RH
4	5	D4067-041	412 JOGGLED WEARPLATE
5	6	D4069-1	SPACER
6	14	AN4C6A	BOLT
7	13	MS21043-3	NUT
8	20	MS21043-4	NUT
9	13	AN3C5A	BOLT
10	6	AN4C12A	BOLT
11	20	NAS1149C0432R	WASHER
12	20	NAS1149C0463R	WASHER



SECTION A-A C6-3
ROTATED 90° CW, SCALED 4X
6 PL

- D4058-042 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 23.5 lbs
 - 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
TRANSFER DRILL $\phi 0.191$ " HOLE FROM D4015-041 TO D4058-2.
CHAMFER HOLE 0.03 X 45°.
FASTEN USING PRESCRIBED HARDWARE
 - 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4058	REV. A
MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE FWD SKI ASSY	SCALE
DE APPR.			NTS
DATE	10.03.31	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-04-03

W/O 57101

